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ABSTRACT:

CHG DATE=19990617 STATUS=O> An indexable insert for milling comprises a metal base (1) which is made of cemented carbide and a subcutting edge (3) consisting of a sintered CBN compact (2) and a flat drag type cutting edge (4) which are brazed to the metal base (1) or bonded thereto by integral sintering. A subcutting edge angle (β), a negative land angle (θ) and a negative land width (L) are set at 30 DEG to 60 DEG , 30 DEG to 45 DEG and 0.05 to 0.40 mm respectively, while the subcutting edge (3) has a straight shape. Due to this structure, the indexable insert has excellent cutting performance particularly in face milling of parts which are made of gray cast iron, and the tool life can be extended. □ □